

Work Order ID 70767

Wednesday, June 15, 2011 9:06:53 AM



Page 1

Item ID:	D2876	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Saddle Spacer					
Start Date:	6/15/2011	Start Qty:	24.00		Cust Item ID:	
Required Date:	6/22/2011	Req'd Qty:	24.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	6/15/11	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2876	Rev B								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D 2876	<input type="checkbox"/> Dwg Rev: <u>B</u>	<input type="checkbox"/> Prog Rev: <u>B</u>	<input type="checkbox"/> 2-					
-6061.100	Debur if necessary								

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

B11-7-5

EP 11/27/06

B11-7-5

Counters
(739)

Sulezke

Work Order ID 70767

Wednesday, June 15, 2011 9:06:53 AM

Page 2

Item ID: D2876

Accept

Revision ID:

Item Name: Saddle Spacer

Start Date: 6/15/2011 Start Qty: 24.00

Required Date: 6/22/2011 Req'd Qty: 24.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

Remove tabs and Tumble

0.00

0.00

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

150



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

29 6 BR 11-7-6.






29 x 8 m / 4/07/06



Work Order ID 70767



Wednesday, June 15, 2011 9:06:53 AM



Page 3

Item ID: D2876 Accept  Setup Start 
Revision ID: Stop 
Item Name: Saddle Spacer
Start Date: 6/15/2011 Start Qty: 24.00  Cust Item ID:
Required Date: 6/22/2011 Req'd Qty: 24.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Packaging Packaging	Identify as per dwg & Stock Location: <u>25</u> Memo	0.00 0.00				11/7/11	esf	(29x)	
170  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/7/11 MF 11-07-08

Picklist Print

Wednesday, June 15, 2011 9:07:00 AM

Page 1

Work Order ID: 70767



Parent Item: D2876



Parent Item Name: Saddle Spacer



Start Date: 6/15/2011

Required Date: 6/22/2011

Start Qty: 24.00

Required Qty: 24.00

Comments: Esr Rev:B 00.05.19 Added inspect level 8 EC
IPP Rev:C Now M6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100 		Purchased	No			100	sf	2.5000	0.0516	1.303579	1.5		
6061-T6 .100 Sheet											B11-7-5		

Location

Loc Qty

Loc Code

MAT021

2.5

102201

2.5

102201

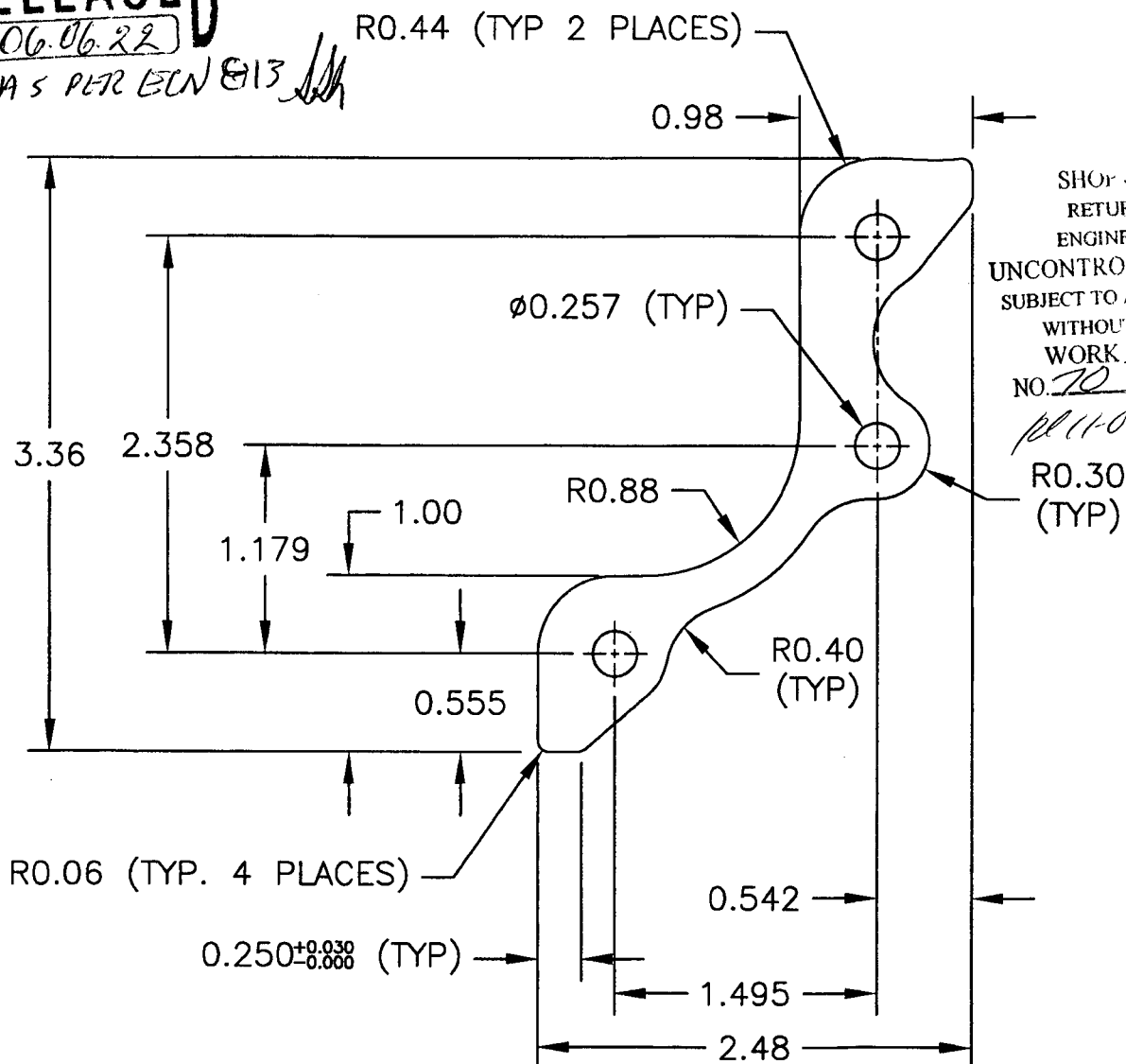
30



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2876	REV. B SHEET 1 OF 1
DATE 06.06.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.06.02	MATERIAL CHANGE	

RELEASED
06.06.22

AS PER ECN 813



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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